

Work Order ID 64427



Page 1

Monday, December 06, 2010 8:54:55 AM

Item ID: D2228

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Plate

Start Date: 12/6/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

PA

Date: 10-12-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2228	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2228 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

5050 - .063

B10-12-14

42

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-12-14

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/12/15

counter.
42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>11</u>	<u>10</u>	<u>12</u>	<u>15</u> (42)
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <u>M115951</u> Memo START TIME: <u>9:15</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>9:45</u>	0.00 0.00				<u>42</u>	<u>10-12-16</u>		
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>42</u>	<u>10/12/16</u>		

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 9

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/10 SP (42X)

10/12/10 HJ

U 10.12.10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 8:55:00 AM

Page 1

Work Order ID: 64427

Parent Item: D2228

Parent Item Name: Bracket Plate



Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐B☐00.08.22☐Re-format☐EC☐
IPP C 07.03.20 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.063		Purchased	No			100	sf	159.0000	0.0227	0.454			
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5052-H32 .063 Sheet



B10-12-14

Location

Loc Qty

Loc Code

MAT

159

114322

159

112442

112442

48

W/O:		WORK ORDER CHANGES					
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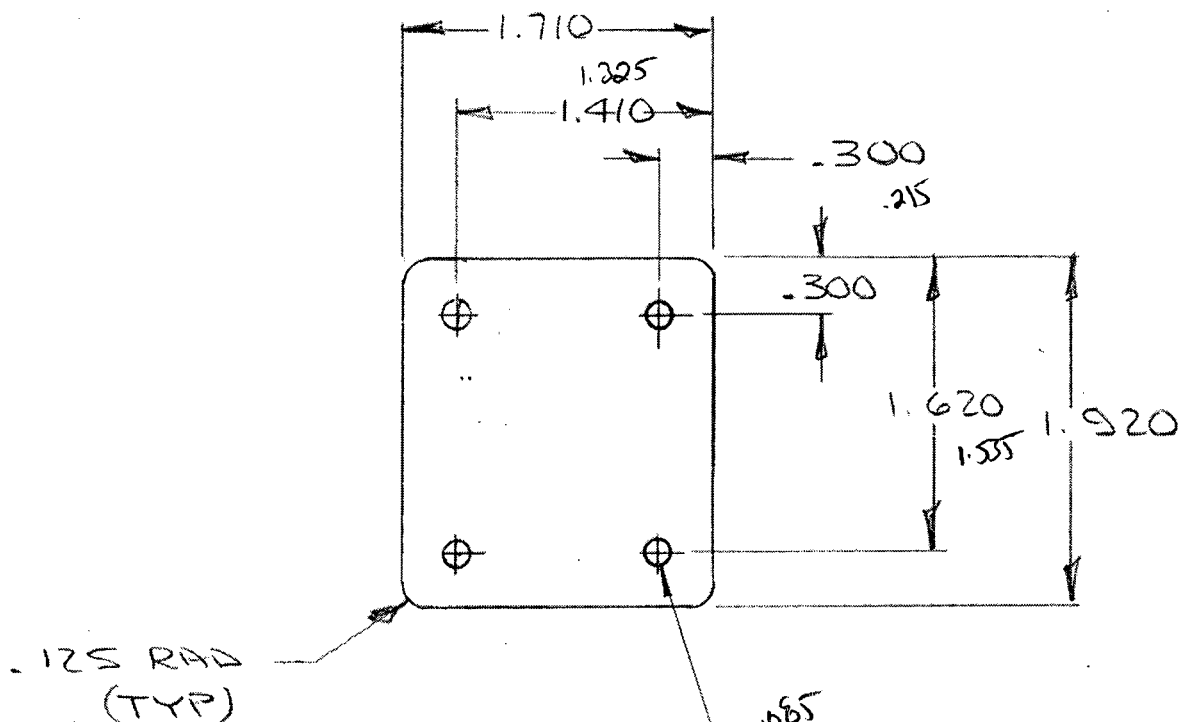
NOTE: Date & initial all entries

DART



DRAWN BRADLEY 94.2.23		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.2.23		DRAWING NO. D2228	REV. B
STRESS		TITLE BACKING PLATE	
B	00.09.11	UPDATE FINISH SPEC. #4	

RELEASED
00.04.12 #



MATERIAL: 5052-H32 .063 THICK
(QQ-A-250/8)

FINISH : CHEMICAL CONVERSION COAT PER DART QSI COS 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI COS 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44427

BS10-12-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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